

Work Order ID 73972

Tuesday, September 20, 2011 10:21:40 AM



Page 1

Item ID: D2565-109

Accept



Setup Start



Revision ID:

Item Name: Strut

Stop



Start Date: 9/20/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/11/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: *MF* Date: *11-09-20*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2565

Rev E

100

Punch ends and deburr as per dwg
NC BRAKE

0.00



Brake NC

Memo

0.00

SB 12/01/23

(10)

Brake NC

Punch as per Dwg D2565 using DT 8313

110

Small Fab

0.00



Small Fab

Memo

0.00

Al 12/01/28

(10)

φ

Small Fab

Deburr

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

512/02/08

(10)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:45

0.00

400 °F

4:15

10X4 M-12/02/04

140

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

10 BL 12710

150

Identify as per dwg & Stock Location:

0.00



Packaging

Packaging

Memo

0.00

Change Place

258

12/10sf/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Setup Start



Revision ID:

Item Name: Strut

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Cust Item ID:

Required Date: 10/11/2011 Req'd Qty: 10.00



Customer:

Reference:


Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

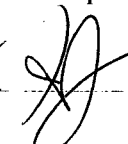
Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
									
QC	Memo	0.00							
Quality Control									

12/2/15 12-02-15
(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 20, 2011 10:21:37 AM

Page 1

Work Order ID: 73972

Parent Item: D2565-109

Parent Item Name: Strut



Start Date: 9/20/2011

Required Date: 10/11/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: ☐F☐02.04.16☐Added dwg Rev.C1☐NG☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	98.3496	1.0258	10.79789			



304 RD Tube .750 x .049W



SB 12/01/23

Location	Loc Qty	Loc Code
MAT017	98.34963	
109314	9.333	
111619	3	
112187	4	
112800	11	
114852	2.75	
116108	3	
116720	1.833	
117797	0.75	
117983	7.091	
118390	55.59263	

*M119644
*M119160

3
3
8
3,0774
3,0774
8.2044
(14)

W/O:		WORK ORDER CHANGES					
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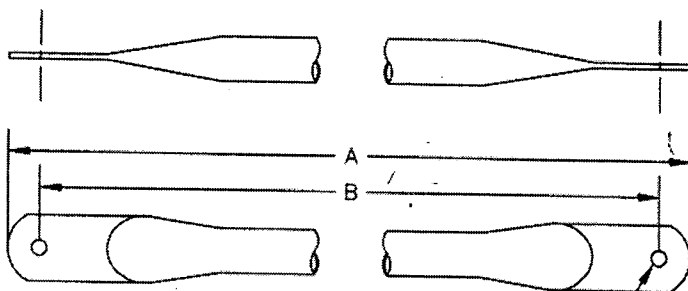
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DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05				TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE			
B	97.03.15	CORRECT D2565-111 DIM. A			
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)			
D	02.06.05	ADD -3XX PARTS; ADD FINISH			
E	04.05.05	ADD D2565-401-411; RMV ANGLE D			

RELEASED
04.05.05



PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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